

Work Order ID 73971

Tuesday, September 20, 2011 10:21:32 AM

Page 1

Item ID: D2565-107

Accept

Setup Start

Revision ID:

Stop

Item Name: Strut

Start Date: 9/20/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 10/4/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: *MUF*

Date: *11-09-20*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:


Run


Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2565	Rev E

100	Punch ends and deburr as per dwg	0.00							
	NC BRAKE								
Brake NC	Memo	0.00		<i>SB 12/01/23</i>				<i>(10)</i>	
Brake NC	Punch as per Dwg D2565 using DT 8313								

110	Small Fab	0.00							
	Small Fab								
Small Fab	Memo	0.00		<i>SB / FF 12-01-23</i>				<i>(10)</i>	
Small Fab	Deburr								

120	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00		<i>S 12/01/23</i>				<i>(RCU)</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID:	D2565-107	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Strut					
Start Date:	9/20/2011	Start Qty:	10.00		Cust Item ID:	
Required Date:	10/4/2011	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
	Powdercoat								
Powder Coating									
<div style="display: flex; justify-content: space-between;"> <div> <p><i>M11A480</i></p> </div> <div> <p>Memo</p> <p>START TIME: <u>12:00</u></p> <p>OVEN TEMPERATURE: <u>400°F</u></p> <p>FINISH TIME: <u>12:30</u></p> </div> </div>									
140	QC3- Inspect Part Finish	0.00							
	QC								
Quality Control									
<div style="display: flex; justify-content: space-between;"> <div></div> <div> <p>Memo</p> </div> </div>									
150	Identify as per dwg & Stock Location:	0.00							
	Packaging								
Packaging									

10x of M-12/01/23

10 B 12-23.

12/1/23

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Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 9/20/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/4/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12/1/23

MF
12-01-23

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Picklist Print

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Page 1

Work Order ID: 73971

Parent Item: D2565-107

Parent Item Name: Strut



Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: ☐ F ☐ 02.04.16 ☐ Added dwg Rev.C1 ☐ NG ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.750W.049

Purchased

No

100

f

98.3496

1.1191

11.78



304 RD Tube .750 x .049W



5 12/01/23

Location

Loc Qty

Loc Code

MAT017

98.34963

109314

9.333

111619

3

112187

4

112800

11

114852

2.75

2 116108

3

2 116720

1.833

1 117797

0.75

1 117983

7.091

2 118390

55.59263

117030

2

7.091

11191

2

17.091

W/O:		WORK ORDER CHANGES					
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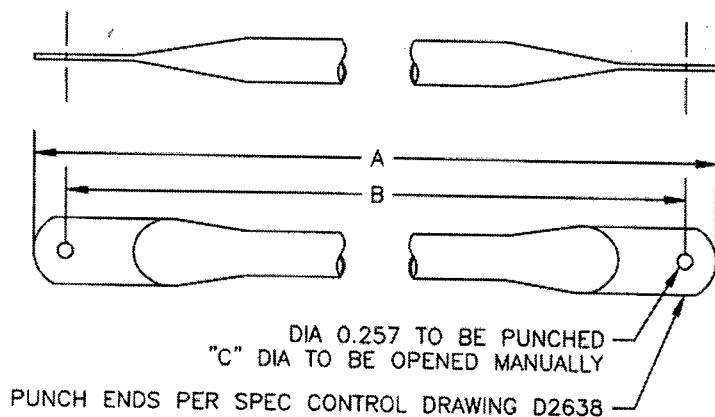
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05



PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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